



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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D206-667-207BL
Job Sheet 192117



Part No: D206-667-207BL

Job Qty: 1 pcs

Part Name: Aft Crosstube - Mid Height 206L / L1 / L3 / L4, Blue



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 3/18/19

Job Tracking No:

Due Date: 4/12/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier	Sign-off
					Setup Hrs	Run Hrs		
110	Crosstubes - Bend - 1	1 pcs	4/12/19	4/12/19	0.00	4.35	Crosstubes - Bend	GP 19-03-28
120	QC 15	1 pcs	4/12/19	4/12/19	0.00	0.00	QC 15 - 12	
							QC 15 - 3	
							QC 15 - 47	
							QC 15 - 49	
							QC 15 - 58	
							QC 15 - 9	
130	Crosstubes - 2 - B4B	1 pcs	4/12/19	4/12/19	0.00	2.86	Crosstubes - 1 - B4B	
							Crosstubes - 2 - B4B	
							Crosstubes - 3 - B4B	
							Crosstubes - 4 - B4B	
140	Crosstubes - 3 - B4B	1 pcs	4/12/19	4/12/19	0.00	0.55	Crosstubes - 1 - B4B	
							Crosstubes - 2 - B4B	
							Crosstubes - 3 - B4B	
							Crosstubes - 4 - B4B	
150	QC 7	1 pcs	4/12/19	4/12/19	0.00	0.00	QC 7 - 10	
							QC 7 - 13	
							QC 7 - 14	
							QC 7 - 15	
							QC 7 - 17	
							QC 7 - 18	
							QC 7 - 19	
							QC 7 - 2	
							QC 7 - 28	
							QC 7 - 3	
							QC 7 - 30	
							QC 7 - 34	
							QC 7 - 36	
							QC 7 - 37	
							QC 7 - 41	
							QC 7 - 47	
							QC 7 - 48	

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DART
AEROSPACE

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Container No: S167282



Part: D206-667-207BL

Job No: 192117

Serial No/Batch: S167282

Revision:

Inspector:

Exp Date:

Instructions:

TC STC SH01-5 Issue 3p-FAA-STC SH01304NY 05/12/15, JCAB JAI

				QC 7 - 51	
				QC 7 - 58	
				QC 7 - 59	
				QC 7 - 60	
				QC 7 - 9	DAS
				QC 7 - 68	APR 03 2019 68
				QC 7 - 50	9-89
				QC 7 - 67	
				QC 7 - 40	
160 QC 5	1 pcs	4/12/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 42	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	DAS
				QC 5 - 68	APR 03 2019 68
				QC 5 - 9	9-89
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
170 Outsource - 2 - NDT per QSI038	1 pcs	4/12/19		SKY002-VC	POO 43076 APR 03 2019
180 Packaging 2-1 - Receive - B4B	1 pcs	4/12/19	0.00 0.00	Packaging 2 - 1 - B4B	
				Packaging 2 - 2 - B4B	
				Packaging 2 - 3 - B4B	
				Packaging 2 - 5 - B4B	
				Packaging 2 - 4 - B4B	APR 11 2019
				Packaging 2 - 6 - B4B	
				Packaging 2 - 7 - B4B	
				Packaging 2 - 8 - B4B	
				Packaging 2 - 9 - B4B	
				Packaging 2 - 10 - B4B	
				Packaging 2 - 11 - B4B	
				Packaging 2 - 12 - B4B	
				Packaging 2 - 13 - B4B	
				Packaging 2 - 14 - B4B	
				Packaging 2 - 15 - B4B	
				Packaging 2 - 16 - B4B	
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				Packaging 2 - 18 - B4B	
				Packaging 2 - 19 - B4B	
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DAS
13
9-89

					Packaging 2 - 31 - B4B	
					Packaging 2 - 32 - B4B	
					Packaging 2 - 33 - B4B	
					Packaging 2 - 34 - B4B	
					Packaging 2 - 35 - B4B	
					Packaging 2 - 36 - B4B	
190 QC 5	1 pcs	4/12/19	0.00 0.00		QC 5 - 10	
					QC 5 - 12	
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					QC 5 - 42	
					QC 5 - 43	
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					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	DAS APR 11 2019 58
					QC 5 - 9	9-89
					QC 5 - 50	
					QC 5 - 30	
					QC 5 - 40	
195 Spray Paint - 2 - B4B	1 pcs	4/12/19	0.00 0.00		Spray Paint - 1 - B4B	RD 19-4-11
					Spray Paint - 2 - B4B	
					Spray Paint - 3 - B4B	
					Spray Paint - 4 - B4B	
200 Outsource - 11 - Paint	1 pcs	4/12/19			ATE003-VC	NR
205 Packaging 2-2 - Receive - B4B	1 pcs	4/12/19	0.00 0.00		Packaging 2 - 1 - B4B	NR
					Packaging 2 - 2 - B4B	
					Packaging 2 - 3 - B4B	
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				Packaging 2 - 31 - B4B	
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				Packaging 2 - 34 - B4B	
				Packaging 2 - 35 - B4B	
				Packaging 2 - 36 - B4B	
210 QC 14	1 pcs	4/12/19	0.00 0.00	QC 14 - 15	
				QC 14 - 2	
				QC 14 - 34	
				QC 14 - 41	• A8 19-4-17
				QC 14 - 51	
				QC 14 - 58	
				QC 14 - 59	
				QC 14 - 9	
				QC 14 - 68	
				QC 14 - 40	
				QC 14 - 19	
220 Crosstubes - 4 - B4B	1 pcs	4/12/19	0.00 2.86	Crosstubes - 1 - B4B	
				Crosstubes - 2 - B4B	
				Crosstubes - 3 - B4B	
				Crosstubes - 4 - B4B	A8 19-4-20
230 Crosstubes - 5 - B4B	1 pcs	4/12/19	0.00 1.91	Crosstubes - 1 - B4B	
				Crosstubes - 2 - B4B	
				Crosstubes - 3 - B4B	
				Crosstubes - 4 - B4B	• A8 19-4-20
240 QC 5	1 pcs	4/12/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 42	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	DAS APR 25 2019 68
				QC 5 - 9	9-89
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
250 Packaging 1-2 - Pick Kit - B4B	1 pcs	4/12/19	0.00 0.00	Packaging 1 - 1 - B4B	
				Packaging 1 - 2 - B4B	
				Packaging 1 - 3 - B4B	
				Packaging 1 - 4 - B4B	
				Packaging 1 - 5 - B4B	
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				Packaging 1 - 17 - B4B	
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				Packaging 1 - 23 - B4B	P.C. APR 24 2019
				Packaging 1 - 24 - B4B	
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				Packaging 1 - 32 - B4B	
				Packaging 1 - 33 - B4B	
				Packaging 1 - 34 - B4B	
				Packaging 1 - 35 - B4B	
				Packaging 1 - 36 - B4B	
260 QC 4	1 pcs	4/12/19	0.00 0.00	QC 4 - 28	
				QC 4 - 42	
				QC 4 - 58	
				QC 4 - 69	
				QC 4 - 9	
				QC 4 - 46	
265 DC - 1 - B4B	1 pcs	4/12/19	0.00 0.00	DC - 1 - B4B	DAS 46 APR 25 2019 9-89
				DC - 2 - B4B	DAS 46 APR 25 2019 9-89
270 Packaging 3-1 - Stock - B4B	1 pcs	4/12/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
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				Packaging 3 - 31 - B4B	

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				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
280 QC 21 - FG	1 pcs	4/12/19	0.00 0.00	QC 21 - FG - 21	DAG
				QC 21 - FG - 70	21
				QC 21 - SA - 53	9-35

Part Op 110 - CNC Alpha 160 Bender - Bend tube as per Dwg D206-667-247 using CNC bender program D206-667-2075 2019
 Descriptions: 120 - QC15- Crosstube Dimensional Check
 130 - Crosstubes ***** ENSURE PROPER JIG POSITIONING BEFORE DRILLING***** , VERIFIED BY: *****
 ***** 1-Drill pilot holes in tube using drill Jig DT8583 & DT8584 as per Dwg D206-667-247. Drill all (3) top holes. Holes facing inboard. Drill and Ream all holes in tube to finish size using drill Jig DT8583 & DT8584 as per Dwg D206-667-247 ***** ENSURE PROPER JIG POSITIONING BEFORE DRILLING***** , VERIFIED BY: *****
 2- Drill fwd rivet holes using drill Jig DT8787 fwd as per Dwg D206-667-247. Note: FWD side has 3X top holes facing inboard. 3- C'sink holes as per dwg D206-667-247. Allow rivet to sit below surface to compensate for paint. 4- Flip tube and switch drilling Jigs from right to left, left to right. Locate Jigs off existing holes using "T" pins. Drill ONLY 2 top holes ONLY plug most bottom hole to prevent accidental drilling. Drill holes and ream using drill Jig DT8583 & DT8584 as per Dwg D206-667-247. Drill only the top (2) holes. Drill & ream the top (2) hole
 140 - Crosstubes Chemical Conversion ***IMMEDIATELY AFTER GRINDING*** 1- PRESSURE WASH X-TUBE INSIDE AND OUT 2- ALODINE AND ACID ETCH X-TUBE INSIDE AND OUT AS PER QSI005.
 150 - QC7-Inspect Chemical Conversion Coat
 160 - QC5- Inspect part completeness to step on W/O
 170 - Outsource process - NDT per QSI038 4.1 *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE*** Liquid Penetrant Inspection as per QSI 038Or Issue P/O: _____ LPI as per ASTM 1417 Level 2 Attach copy of NDT results to work order
 180 - Receive & Inspect for Damage & Mat'l Certs *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE*** Ensure copy of NDT results attached to work order.
 190 - QC5- Inspect part completeness to step on W/O *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE*** Ensure results are as per Dwg D206-667-247
 195 - Spray Paint / NDT Room
 200 - ISSUE PO _____ *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE*** ***VERIFY BY _____ BATCH # TO MATCH W/O _____ ***VERIFY BY _____ PART # TO MATCH W/O _____ ***MASK SCRIBE B# & P# AND VERIFY*** 1-Prime inside and outside crosstube as per QSI 005 4.2 2-Paint outside crosstube as per QSI 005 4.2 PRIME: Start Time: _____ Finish Time: _____ PAINT: DELFLEET BLUE _____ Start Time: _____ Finish Time: _____ CLEAR DELFLEET B _____
 205 - Receive & Inspect for Damage & Mat'l Certs
 210 - QC14- Inspect Spray Paint Wrap in plastic bag to protect from scratches ***VERIFY BY _____ BATCH # TO MATCH W/O _____ ***VERIFY BY _____ PART # TO MATCH W/O _____
 220 - Crosstubes - 1-Install nut plates as per Dwg D206-667-247.
 230 - 1-Abrade mating surfaces of support and crosstube with 400 grit sandpaper, clean the area with 4105S wash 'n' wipe 2-Install supports with Proseal 890 per DSI9565 and QSI 015 A/R Proseal 890 Batch: 2146134 exp 10/193- Torque bolts as per dwg
 240 - QC5- Inspect part completeness to step on W/O ***VERIFY BY _____ BATCH # TO MATCH W/O _____ ***VERIFY BY _____ PART # TO MATCH W/O _____
 250 - Pick Kit
 260 - QC4- 100% Inspect kits for completeness ***VERIFY BY _____ BATCH # TO MATCH W/O _____ ***VERIFY BY _____ PART # TO MATCH W/O _____
 265 - Document Control Photocopy bluefile and create labels as per PPP D206-667-207 chg 002
 270 - Identify as per dwg & Stock Location: _____ Identify and pack for shipping as per PPP D206-667-207 Location: _____ PPP Rev: _____
 280 - QC21- Final Inspection - Work Order Release

Job BOM

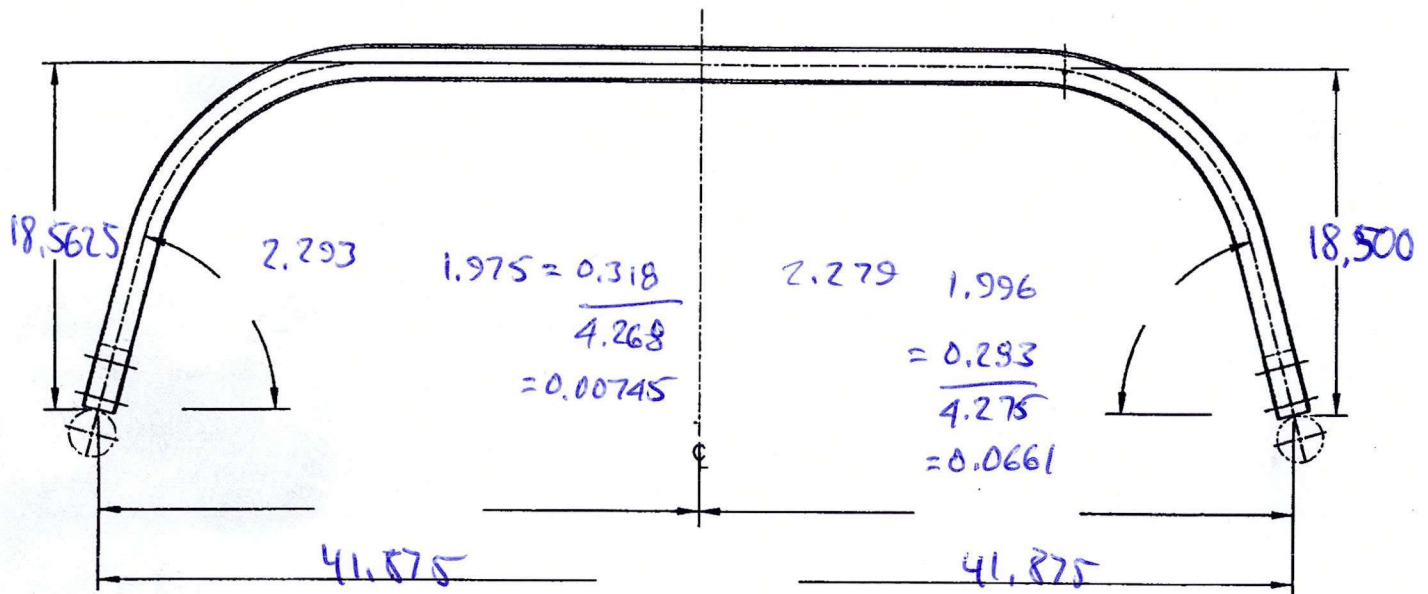
Part / Item	Component Name	Quantity	Operation	Container
D206-667-247TRN	Crosstube Assembly, Mid Aft	1 pcs (1 ea)	110-Crosstubes - Bend - 1	5012 449.
D2873-043	Nut Plate Assembly	2 Ea (2 ea)	220-Crosstubes - 4 - B4B	
D2873-045	Nut Plate Assembly	2 pcs (2 ea)	220-Crosstubes - 4 - B4B	
MS20601-AD4W10	Rivet	14 Ea (14 ea)	220-Crosstubes - 4 - B4B	
D2892-1	Support	2 pcs (2 ea)	230-Crosstubes - 5 - B4B	
D3595-063-450	Rubber Cushion 0.63" Wide X 4.50" Long	4 pcs (4 ea)	230-Crosstubes - 5 - B4B	
MS21920-22	Clamp	4 Ea (4 ea)	230-Crosstubes - 5 - B4B	
AN5-10A	Bolt	10 Ea (10 ea)	250-Packaging 1-2 - Pick Kit - B4B	548 586
AN5-32A	Bolt	4 Ea (4 ea)	250-Packaging 1-2 - Pick Kit - B4B	5058983-3
AN5-34A	Bolt	4 Ea (4 ea)	250-Packaging 1-2 - Pick Kit - B4B	509 416
MS21042L5	Nut	4 Ea (4 ea)	250-Packaging 1-2 - Pick Kit - B4B	5149 145
NAS1149D0563J	Washer	18 Ea (18 ea)	250-Packaging 1-2 - Pick Kit - B4B	5167 648

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
110-Crosstubes - Bend - 1	D206-667-247TRN	1	8	0
220-Crosstubes - 4 - B4B	D2873-043	② 5145879	75	0
	D2873-045	② 5133728	42	0
	MS20601-AD4W10	① 5030481	272	0
230-Crosstubes - 5 - B4B	D2892-1	② 5077394	10	0
	D3595-063-450	④ 5150042	39	0
	MS21920-22	④ 5155978	41	0
250-Packaging 1-2 - Pick Kit - B4B	AN5-10A	10	340	0
	AN5-32A	4	385	0
	AN5-34A	4	39	0
	MS21042L5	4	723	0
	NAS1149D0563J	18	1,495	0
Part Specifications				
Specifications could not be found.				

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DART AEROSPACE LTD	Work Order:	192118
Description: Crosstube Mid Aft (206L)	Part Number:	D206-667-207
Inspection Dwg: D206-667-247 Rev: A		Page 1 of 1

Required Dimension	Min	Max
Height	18.34	18.60
1/2 Span	41.79	42.05
Angle	54°	56°
Total Span	83.59	84.09
Bending Passes	10	--
Crushing	--	6%



	Side A	Side B
Bending Passes	14	12
Crushing	7.4%	6.6
Comments		
Acceptable per DR-1059 Rev. A 9/14/3/26		

QC15 Inspection	
Date	

Rev	Date	Change	Revised by	Approved
A	12.02.15	New Issue	KJ	
B	12.04.16	Added bending, crushing dimensions	KJ	

Item	Qty -247	Part Number	Description
1	X	D206-667-247	CROSSTUBE ASSEMBLY (206L MID AFT)
2	1	D6004-115	CROSSTUBE
3	2	D2873-043	NUT PLATE
4	2	D2873-045	NUT PLATE
5	2	D2892-1	SUPPORT
6	4	D3595-063-450	RUBBER CUSHION
7	4	MS21920-22	CLAMP
8	14	MS20601AD4W10	RIVET (OR NAS9302B-4-10)
9	A/R	PROSEAL 890 B-2	SEALANT, AMS-S-8802 CLASS B-2

GENERAL NOTES:

- 1) MATERIAL: MANUFACTURED FROM D6004-115
FINISHED LENGTH = 99.78±0.020
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT OUTSIDE PER DART QSI 005 4.2
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED.
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
- 6) IDENTIFICATION: SCRIBE DART PART NUMBER "D206-667-247" AND BATCH NUMBER ON INSIDE OF CUFF PER DART QSI 044 6.4 (VIBRATING STYLUS).
- 7) WEIGHT: 21.1 lbs (-607 = 17.7 lbs)
- 8) PART IS SYMMETRIC ABOUT CENTERLINE.
- 9) RUN CUTTER OFF PART WHERE INDICATED. BLEND OUT EDGE LONGITUDINALLY. TRANSITION SHOULD BE SMOOTH.
- 10) BEND PROGRESSIVELY WITH A MINIMUM OF 8 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
- 11) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- 12) TO INSTALL D2892-1 SUPPORT: ABRASE MATING SURFACE OF SUPPORT AND CROSSTUBE WITH 180-GRIT SANDPAPER AND REMOVE RESIDUE WITH MEK (OR EQUIVALENT). APPLY A 0.04" TO 0.07" THICK LAYER OF PROSEAL 890 CLASS B-2 (OR AMS-S-8802 CLASS B-2) SEALANT TO MATING SURFACE OF SUPPORT.
- 13) INSTALL MS21920-22 CLAMPS WITH D3595-063-450 RUBBER CUSHIONS TO SECURE THE D2892-1 SUPPORT ON TOP SIDE OF THE CROSSTUBE. ENSURE CLAMP MECHANISMS ARE LOCATED ON CROSSTUBE SUPPORTS.
- 14) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 15) TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS ARE SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING. PRIOR TO PACKAGING, RE-CHECK TORQUE ON CLAMPS AFTER PROSEAL 890 SEALANT HAS CURED FOR 72 HOURS.

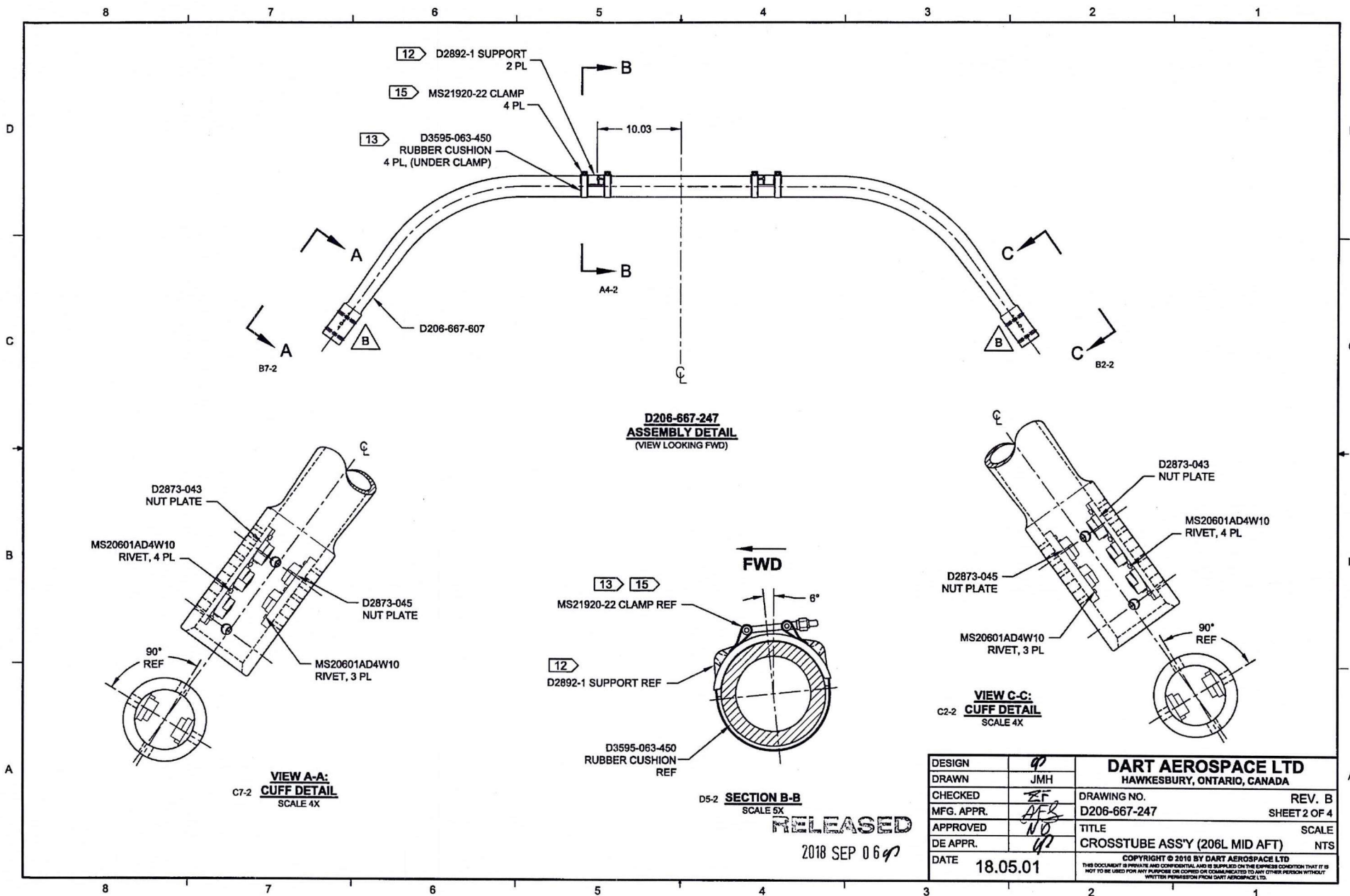
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WITHOUT NOTICE
WORK ORDER

NO. 192117 MWS
19-07-18

RELEASED

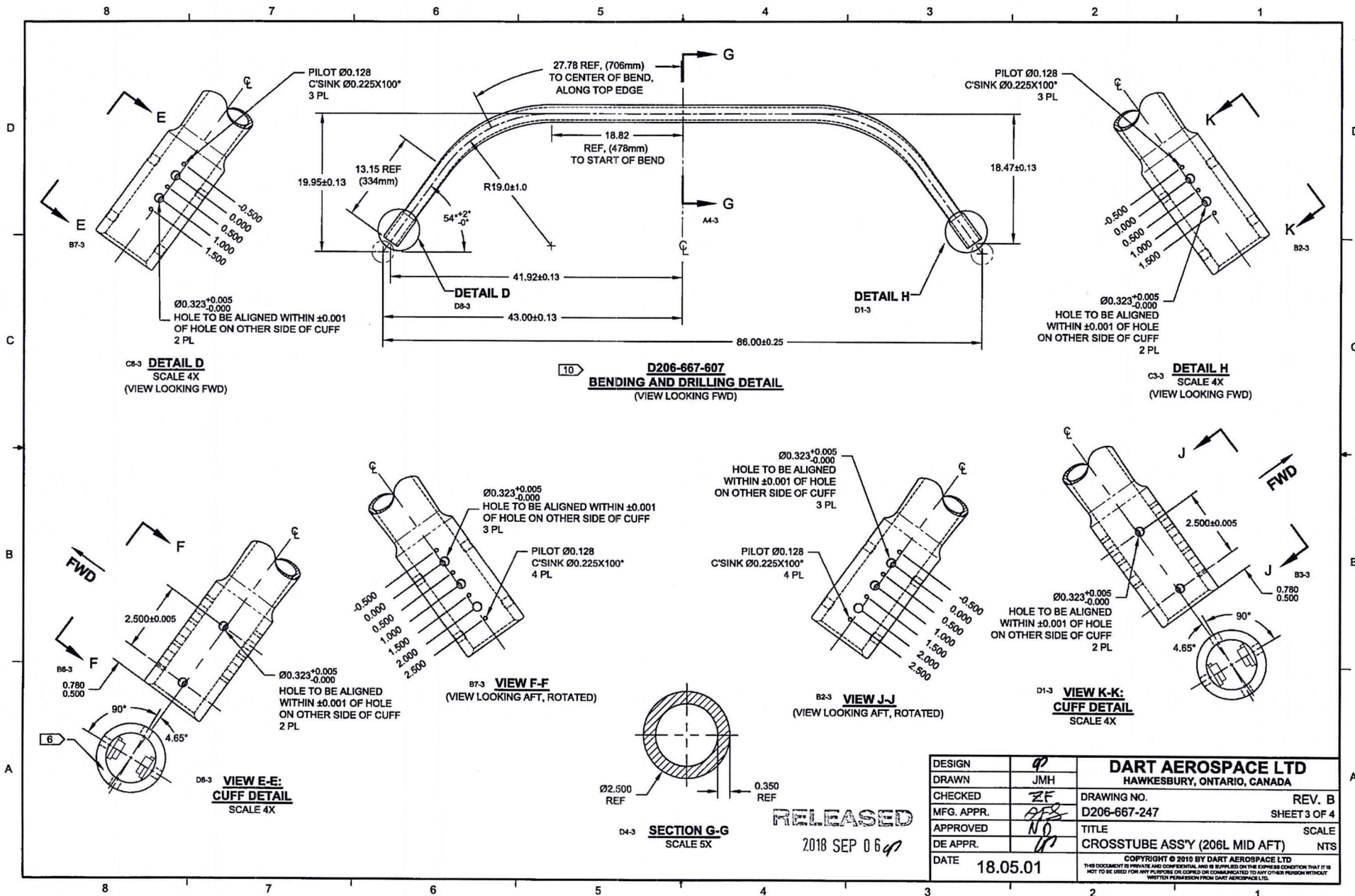
2018 SEP 06
EN 18-777

B	REVISE SHEET 2 ASSEMBLY DETAIL HOLE PATTERN PER CAR18-221. UPDATE PARTS LIST AND GENERAL NOTES 12 & 15 TO INCORPORATE DEO A-1.	JMH	18.05.01
A	NEW ISSUE	CP	10.12.23
REV.	DESCRIPTION	BY	DATE
DESIGN	q	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JMH	DRAWING NO.	REV. B
CHECKED	EF	D206-667-247	SHEET 1 OF 4
MFG. APPR.	BTB	TITLE	SCALE
APPROVED	NO	CROSSTUBE ASS'Y (206L MID AFT)	NTS
DE APPR.	q	DATE 18.05.01	
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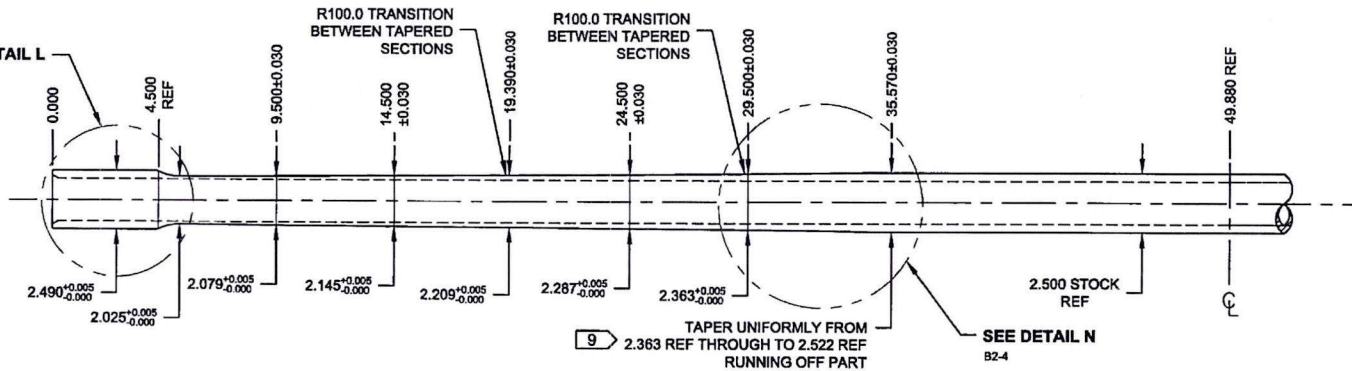
RELEASED

2018 SEP 06

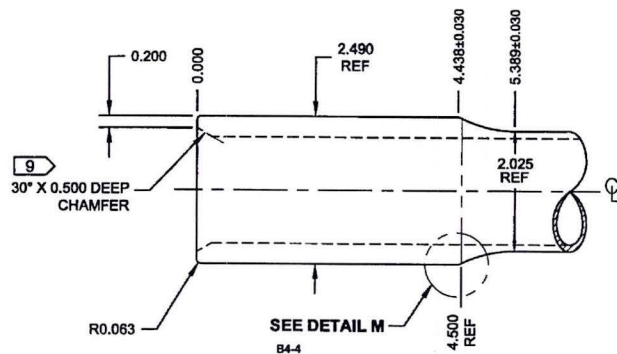


DESIGN	97	DART AEROSPACE LTD	
DRAWN	JMH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	ZF	DRAWING NO.	REV. B
MFG. APPR.	AFB	D206-667-247	SHEET 3 OF 4
APPROVED	NO	TITLE	SCALE
DE APPR.	JP	CROSTUBE ASS'Y (206L MID AFT)	NTS
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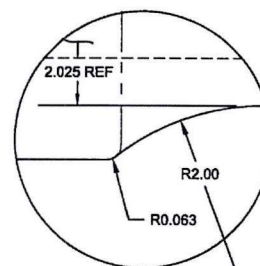
SEE DETAIL L
B7-4



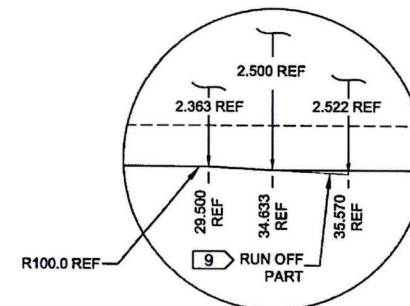
TURNING DETAIL



C7-4 **DETAIL L: CROSSTUBE CUFF**
SCALE 2.5X



B6-4 **DETAIL M: CUFF TRANSITION**
NOT TO SCALE



C4-4 **DETAIL N: TAPER RUN-OFF**
NOT TO SCALE

RELEASED
2018 SEP 06

DESIGN	JP	DART AEROSPACE LTD	
DRAWN	JMH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	ZF	DRAWING NO.	REV. B
MFG. APPR.	JP	D206-667-247	SHEET 4 OF 4
APPROVED	NO	TITLE	SCALE
DE APPR.	JP	CROSSTUBE ASS'Y (206L MID AFT)	NTS
DATE	18.05.01	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

PO043076



Supplier: SKY002-VC
Skyservice
6120 Midfield Road
Mississauga
ON
L5P 1B1 Canada
Phone: 905-678-5636
Fax: 905-678-5841

Attention: Jenne, Heather

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: PO043076

PO Date: 4/3/19

Due Date: 4/11/19

**Purchase Order
Revision:**

Revision Date:

Ship-To Contact: Lavoie, Chantal
clavoie@dartaero.com

Via: Ground

Pymt Terms: Net 30

Freight Terms:

Special Comments:

E-MAILED
APR 10 2019

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	192114	D206-667-107BL	Fwd Crosstube - Mid Height 206L / L1 / L3 / L4, Blue : TC STC SH01-5 Issue 3, FAA STC SR01304NY 05/12/15, JCAB JAPAN STC-32-OSA 02/02/28, EASA STC EASA.IM.R.S.01179 06/07/03, BRAZIL 2009S08-16 09/08/25, BRAZIL 2009S08-17 09/08/25 *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE*** Liquid Penetrant Inspection as per QSI 038Or Issue P/O: _____ LPI as per ASTM 1417 Level 2 Attach copy of NDT results to work order	Firmed	-	4/11/19	1 pcs	0 pcs	1 pcs	\$131.875/pcs	\$131.88
	192115		1 X APR 11 2019	Firmed	-	4/11/19	1 pcs	0 pcs	1 pcs	\$131.875/pcs	\$131.88
	192116		1 X APR 11 2019	Firmed	-	4/11/19	1 pcs	0 pcs	1 pcs	\$131.875/pcs	\$131.88
Sub Total:							3	0	3		\$395.63



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

PO043076



Items											
Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
2	192117	D206-667-207BL	Aft Crosstube - Mid Height 206L / L1 / L3 / L4, Blue : TC STC SH01-5 Issue 3, FAA STC SR01304NY 05/12/15, JCAB JAPAN STC-32-OSA 02/02/28, EASA STC EASA.IM.R.S.01179 06/07/03, BRAZIL 2009S08-16 09/08/25, BRAZIL 2009S08-17 09/08/25 Outsource process - NDT per QSI038 4.1 *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE*** Liquid Penetrant Inspection as per QSI 038Or Issue P/O: _____ LPI as per ASTM 1417 Level 2 Attach copy of NDT results to work order	Firmed	-	4/11/19	1 pcs	0 pcs	1 pcs	\$131.875/pcs	\$131.88
	192118			Firmed	-	4/11/19	1 pcs	0 pcs	1 pcs	\$131.875/pcs	\$131.88
Sub Total:							2	0	2		\$263.75
3	190489	D135-1027-251	Std Height Aft Crosstube - DO NOT USE ISSUE P/O: _____ C OF C IS REQUIRED	Firmed	-	4/11/19	1 pcs	0 pcs	1 pcs	\$131.875/pcs	\$131.88
4	191900	D135-1027-253	Mid Height Aft Crosstube - DO NOT USE ISSUE P/O: _____ C OF C IS REQUIRED	Firmed	-	4/11/19	1 pcs	0 pcs	1 pcs	\$131.875/pcs	\$131.88
	191901			Firmed	-	4/11/19	1 pcs	0 pcs	1 pcs	\$131.875/pcs	\$131.88
Sub Total:							2	0	2		\$263.75
Grand Total:										\$1,055.00	



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

PO043076



Order Notes

Procurement Quality Clauses

A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

CL
A handwritten signature in dark ink, appearing to be "CL" followed by a stylized flourish.

Plex 4/10/19 12:39 PM dart.lavoie.chantal

**skyservice****Work Order Traveler**

Sky Service F.B.O. Inc.

10105 Ryan Avenue, Dorval, Quebec, H9P 1A2

TCCA AMO 53-89 / EASA 145.7142 / BDA AMO 385

WO #: MWO39884	Customer: Dart Aerospace Ltd.	Dept: NDT YUL	Reference: PO043076 ✓
Descr:	PN:	S/N:	Qty: 1
Make:	Model:	Reg:	A/C S/N:
TSN:	CSN:	TSO:	
Task: UNSCHEDULED			Sequence: 1

Work Required:

CARRY OUT NDT INSPECTION (LIQUID PENETRANT) ON 8 CROSSTUBES

ITEM ID: D135-1027-251 STB HEIGHT AFT CROSSTUBE

1 - WORK ORDER ID#: 190489 ✓

ITEM ID: D135-1027-253 MID HEIGHT AFT CROSSTUBE

2 - WORK ORDER ID#: 191900 ✓

3 - WORK ORDER ID#: 191901 ✓

ITEM ID: D206-667-107BL FWD CROSSTUBE - MID HEIGHT 206L / L1 / L3 / L4, BLUE.

4 - WORK ORDER ID#: 192114 ✓

5 - WORK ORDER ID#: 192115 ✓

6 - WORK ORDER ID#: 192116 ✓

ITEM ID: D206-667-207BL

7 - WORK ORDER ID#: 192117 ✓

8 - WORK ORDER ID#: 192118 ✓

DAS
68
9-89

Action Taken:					Date:		Initial/Stamp:	
LIQUID PENETRANT INSPECTION CARRIED OUT ON ITEMS LISTED ABOVE (ITEMS 1-8) AS PER ASTM1417M-16					APR 6 5 2019		DOT-APP 61 53-89 ✕	
NO CRACK FOUND								
PEN ZL-37, MPO23206, CLEANER SKC-S MPO15030, EMU. MPO15896, DEV. MPO23451, UV LIGHT M-20142								
Description	Location	P/N	Qty	Batch	S/N Off	S/N On		

I certified that the maintenance described above has been performed in accordance with the applicable standard of airworthiness.

Signature:	ACA/SCA Stamp DOT-APP 61 53-89	Date: APR 6 5 2019
Name: ANTONINO MARCHETTA		

**skyservice****Work Order Traveler**
Sky Service F.B.O. Inc.

10105 Ryan Avenue, Dorval, Quebec, H9P 1A2

TCCA AMO 53-89 / EASA 145.7142 / BDA AMO 385

WO #: MWO39884	Customer: Dart Aerospace Ltd.	Dept: NDT YUL	Reference: PO43076
Descr:	PN:	S/N:	Qty: 1
Make:	Model:	Reg:	A/C S/N:
TSN:	CSN:	TSO:	
Task: UNSCHEDULED			Sequence: 1

Work Required:

CARRY OUT NDT INSPECTION (LIQUID PENETRANT) ON 8 CROSSTUBES

ITEM ID: D135-1027-251 STB HEIGHT AFT CROSSTUBE

1 - WORK ORDER ID#: 190489

ITEM ID: D135-1027-253 MID HEIGHT AFT CROSSTUBE

2 - WORK ORDER ID#: 191900

3 - WORK ORDER ID#: 191901

ITEM ID: D206-667-107 BL FWD CROSSTUBE - MID HEIGHT 206L / L1 / L3 / L4, BLUE.

4 - WORK ORDER ID#: 192114

5 - WORK ORDER ID#: 192115

6 - WORK ORDER ID#: 192116

7 - WORK ORDER ID#: 192117

8 - WORK ORDER ID#: 192118

D206-667-207 BL.

Action Taken:						Date:	Initial/Stamp:
LIQUID PENETRANT INSPECTION CARRIED OUT ON ITEMS LISTED ABOVE (ITEMS 1-8) AS PER ASTM1417M-16						APR 05 2019	DOT-APP 61 53-89 <i>[Signature]</i>
NO CRACK FOUND							
PEN ZL-37, MPO23206, CLEANER SKC-S MPO15030, EMU. MPO15896, DEV. MPO23451, UV LIGHT M-20142							
Description	Location	P/N	Qty	Batch	S/N Off	S/N On	

I certified that the maintenance described above has been performed in accordance with the applicable standard of airworthiness.

Signature:	<i>[Signature]</i>	ACA/SCA Stamp	Date:
Name:	ANTONINO MARCHETTA	DOT-APP 61 53-89	APR 05 2019